

5422

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

RBEM652V3002101-M-43
Job Sheet 177793

Part No: RBEM652V3002101-M-43 Job Qty: 6 ea
Part Name: Stud
Part Weight: 0 lbs Status: At Planning Priority: Medium
Job Created: 5/17/18 Job Tracking No:
Due Date: 7/9/18 Created By: Logan David
Type: SOLD Description:
Note: DWG RBEM652V3002101-M Rev D IPP Rev A 18.04.03 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
90	Start up Operation	6 Ea	7/9/18	7/9/18	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	6 pcs	7/9/18	7/9/18	0.00	0.60	MORI SL-154		
120	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC2 Machining-4		
130	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC8 Machining-4		
135	Outsource	6 pcs	7/9/18	7/9/18	0.00	0.00	Outsource1 (Atlantic)		
140	Outsource	6 pcs	7/9/18	7/9/18	0.00	0.00	Outsource12		
150	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging2		
160	QC	6 pcs	7/9/18	7/9/18	0.00	0.00	QC6		
210	Packaging	6 pcs	7/9/18	7/9/18	0.00	0.00	Packaging3-1		
220	QC21-SA	6 Ea	7/9/18	7/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG, FC077 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 135 - 1-Issue P/O to Metcore; P/O _____ RC 35-45 2-Bead blast 3- Certificate of Conformity is required
NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***
140 - BLACK OXIDE (RED BARN) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C
Class 1 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R0.750	Tool Steel Round Bar 0.750 dia.	2.1450 ft (.3575 ea)	90-Start up Operation	5075935

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-O1-R0.750	4	22	0

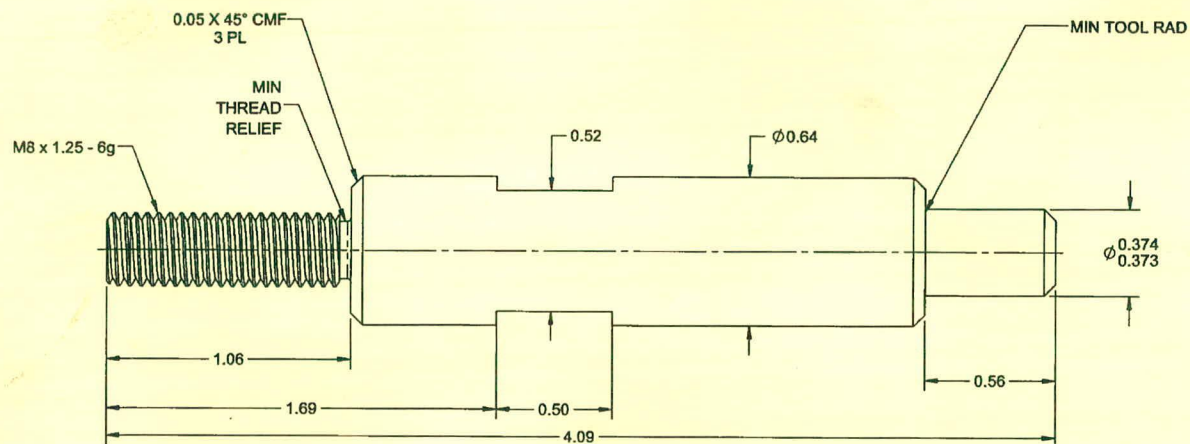
Part Specifications

Specifications could not be found.

Plex 5/17/18 3:33 PM dart.logan.david

2AC
Or
206

2AC
38
98-9



RBEM652V3002101-M-43 STUD

NOTES:

- 1) MATERIAL: O1 (35-45 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1/2/4 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
 X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
 X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL: ACCEPTABLE ON BOTH END

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM 03/28/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/27/2018	TOOL PART #	REV. D
MFG. APPR.	DP 03/27/2018	RBEM652V3002101-M	SHEET 13 OF 17
APPROVED	ML 03/28/2018	TITLE	SCALE
DATE 3/28/2018		TAIL GEAR BOX INPUT SEAL EXCHANGE	NTS
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INSPECTION SHEET

Measured by: JB	Checked by: LF	QC Inspector:
Date: 18-10-31	Date: 18-11-01	Date:

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S123984



Part: RBEM652V3002101 - M - 43

Job No: 177793

Serial No/Batch: S123984

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 11/01/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041570**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041570

PO Date: 11/2/18

Due Date: 11/9/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	177793	RBEM652V3002101-M-43	Stud 1--Issue P/O to Atlantic ; P/O RC 35-45 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/9/18	12 pcs	0 pcs	12 pcs	\$0.01/pcs	\$0.12

12x NOV 13 2018

~~8107 E L AON~~

DAS
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9-89

Line Item Note: ** Need by Nov. 9, is this possible? **



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041570**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	178483	RBT18560-1	1--Issue P/O to Atlantic; P/O RC 45-52 ***Heat treat with expander fixture installed*** ***NOTE***REMOVE EXPANDER FIXTURES BEFORE BEAD BLASTING 2-Bead blast 3- Certificate of Conformity is required -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required ***NOTE***DO NOT SURFACE FINISH RBT560-1 EXPANDER FIXTURES, PLEASE ENSURE TO RETURN EXPANDER FIXTURES TO DART.	Firmed	-	11/9/18	7 pcs	0 pcs	7 pcs	\$0.01/pcs	\$0.07
Grand Total:											\$0.19

7 sets NOV 13 2018

Order Notes

Procurement Quality Clauses

A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 157200
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
PO041570				

Quantity	Part No. / Part Name / Part Description	Pounds
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✓ 7PCS MATERIAL H13
SAND BLAST AND HEAT TREAT TO 45-52RC
FIXTURE, DD, BLACK OXIDE, C OF C, PRT# RBT18560-1, JOB# 178489 ✓

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped: 7

Pounds Shipped: 10.00

So Rec AR

11-9-18

Order No.: 160080

Shipped Complete

Quantity Shipped: 7.00

Received By:

Date:

Pounds Shipped: 10.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/05/2018

Shipping Ticket

Shipper's Name J. B. ROBERTSON LTD		Consignee's Name J. B. ROBERTSON LTD	
Address 1000 BROADWAY NEW YORK 10003		Address 1000 BROADWAY NEW YORK 10003	
Phone NY 1-2345		Phone NY 1-2345	
City NEW YORK		City NEW YORK	
State NEW YORK		State NEW YORK	
Zip 10003		Zip 10003	
Description of Goods 1000 BROADWAY		Description of Goods 1000 BROADWAY	
Quantity 1000		Quantity 1000	
Unit BAGS		Unit BAGS	
Weight 1000		Weight 1000	
Volume 1000		Volume 1000	
Value 1000		Value 1000	
Insurance 1000		Insurance 1000	
Freight 1000		Freight 1000	
Taxes 1000		Taxes 1000	
Total 1000		Total 1000	

Certification

Date: 11/09/2018

Entry Date: 11/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: PO041570

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: h13

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
7	7PCS MATERIAL H13 SAND BLAST AND HEAT TREAT TO 45-52RC FIXTURE, DD, BLACK OXIDE, C OF C, PRT# RBT18560-1, JOB# 178483	10

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:

Harden ROCKWE 45. 52. 50 TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 50 RC AS PER CUSTOMER REQUEST

BLACK OXIDE AS PER CUSTOMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEAN SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

Cricket

